

Date: Tuesday, 10/24/2006 11:02:55 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y
Job Number	: 29135		
Estimate Number	: 10360		
P.O. Number	: <i>N/A</i>	Part Number	: D2350
This Issue	: 10/24/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2350 / D2363
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B / E
Previous Run	: 26488	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/5/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06 10 24		
Comment	: est rev B 0605.17 added ass'y EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.0631 f(s)/Unit Total : 4.2525 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch:

B.26538

J.F. 06/10/27

(4)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 12.150" long

J.F. 06/10/27

(4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

ml 06/10/28

740

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/10/28

4

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/10/30

x4

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

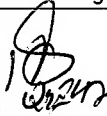
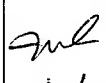
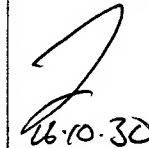

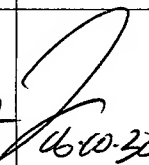
ml 06/10/30

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-30	3.0	Part is short. Should be 2.00 and is 11.985. Part is short		Holes - spacing are good. parts acceptable	 06/10/30	 06-10-30	 06-10-30	 06-10-30

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 29135

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/10/30 x4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

gl 06/10/30 x4

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

gl 06/10/31 x4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/11/17 (x4)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener B26497

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin B26497 B29379

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer M101291-

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 02/11/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 29135

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) *M101390 - 2P M101917 2P*

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw *M13719*

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

M106/11/17 (4)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/20 4

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57171*

06/14/20 (4)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/21 (4)

Job Completion



06.11.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED
960607

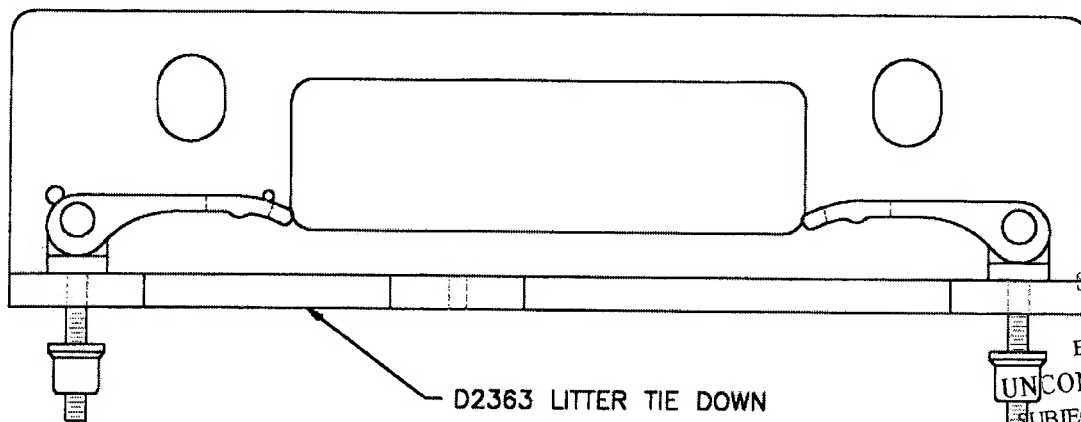
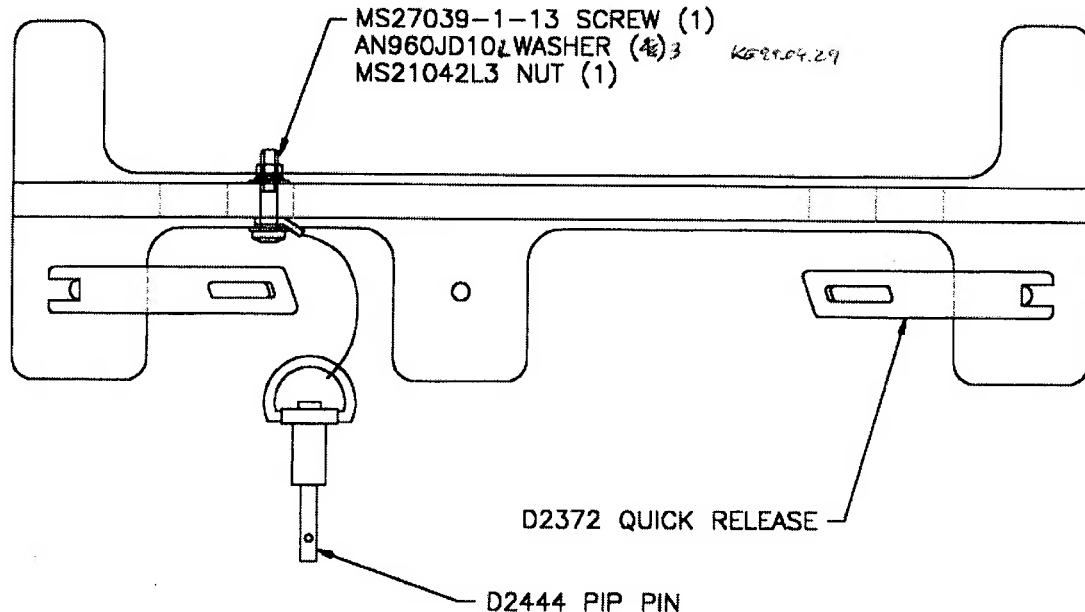
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>KE 99.04.29</i> X 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

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WITHOUT NOTICE
WORK ORDER
NO. 29135



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED	D2350	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		LITTER TIE DOWN ASSEMBLY	

RELEASED
960607



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WITHOUT NOTICE
WORK ORDER
NO. 29135

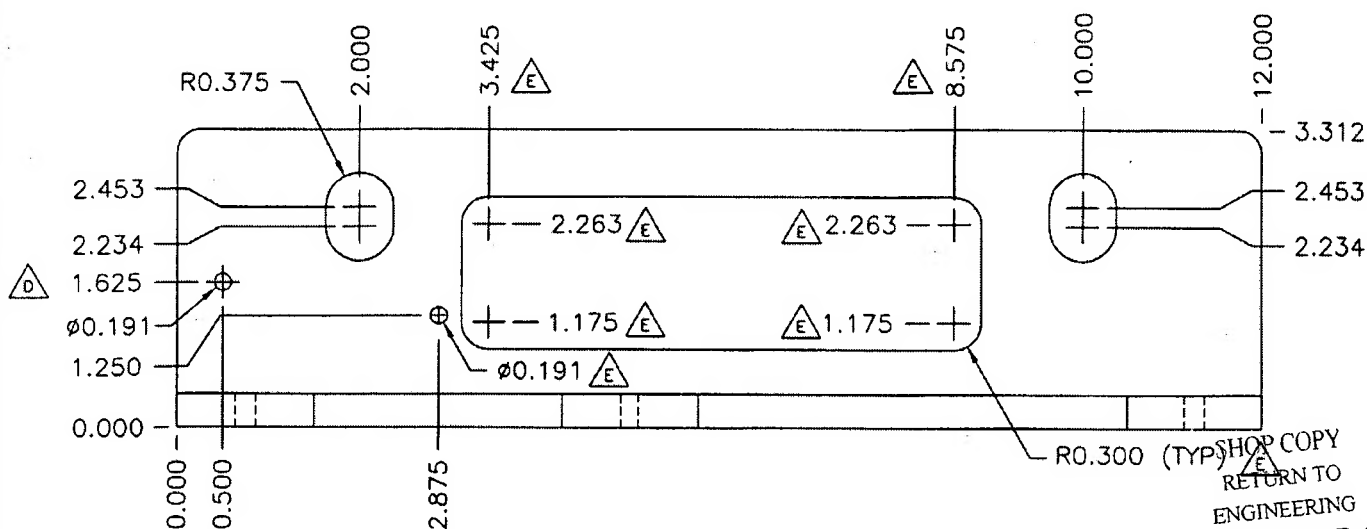
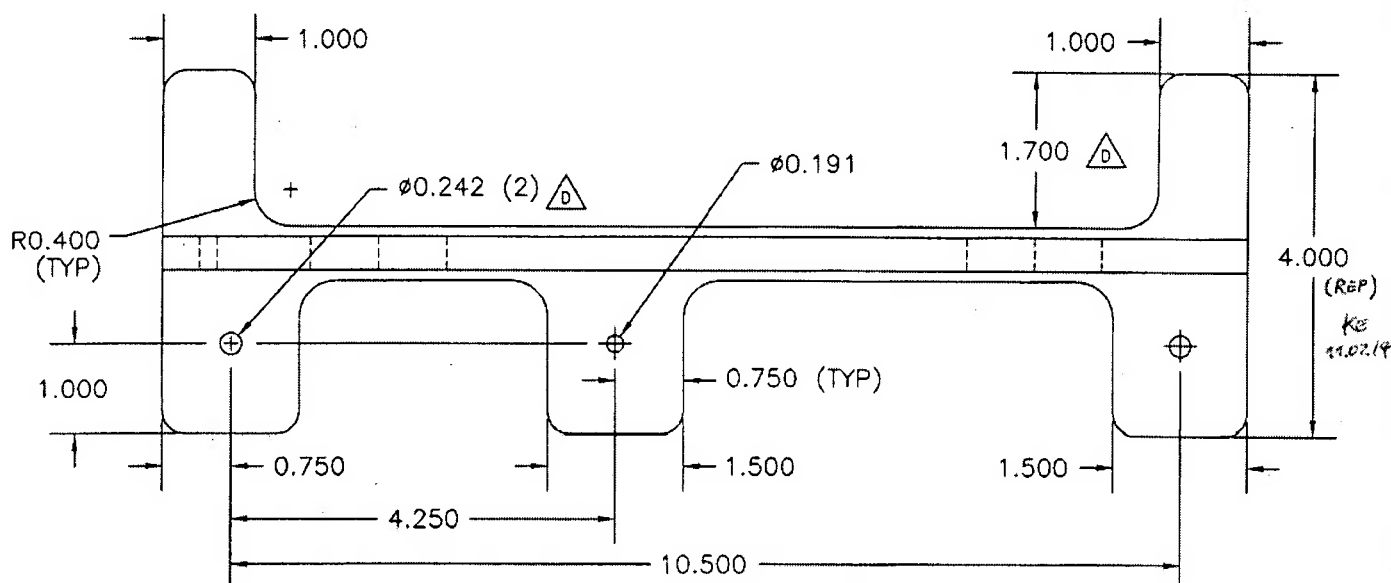


DESIGN BW		DRAWN BY KE		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIEY		APPROVED BW		DRAWING NO. D2363 REV. 0 SHEET 1 OF 1	
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET SCALE 1:2			
A	95.01.14	NEW ISSUE			
B	95.02.14	MODIFIED HOLES			
C	95.03.06	0.191 WAS 0.197			
D	95.03.06	CHANGES TO DIMENSIONS			
E	97.10.01	CHANGES FOR MACHINING			

RELEASED
971003 KE

971003 KE

TSR 4129



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WITHOUT NOTICE

MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

WORK ORDER
NO. 29135

DART AEROSPACE LTD		Work Order: 29135
Description: Litter Tie Down Bracket		Part Number: D2363
Inspection Dwg: D2363, Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	± 0.0	1.001	—			
1.700	± 0.0	1.698	—			
1.000	± 0.0	1.001	—			
4.000	± 0.0	3.995	—			
1.500	± 0.0	1.501	—			
10.500	± 0.05	10.500	—			
0.750	± 0.05	0.750	—			
1.500	± 0.0	1.501	—			
4.250	± 0.05	4.249	—			
0.750	± 0.05	0.749	—			
1.000	± 0.05	1.000	—			
1.250	± 0.05	1.246	—			
Ø 0.191	± 0.05	Ø 0.192	—			
1.625	± 0.05	1.624	—			
2.234	± 0.010	2.234	—			
3.312	± 0.010	3.312	—			
1.175	± 0.010	1.170	—			
0.500	± 0.010	0.500	—			
2.000	± 0.010	1.992	—			
2.875	± 0.010	2.875	—			
3.425	± 0.010	3.420	—			
10.000	± 0.010	10.000	—			
12.000	± 0.010	12.000	—			
Ø 0.242	± 0.010	Ø 0.242	—			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 06/10/28	Date: 06/10/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	